

Work Order ID 144684

April 21, 2016 4:20:40 PM

144684

Page 1

Item ID: D412-702-071

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Comfort Crew Shoulder Harness

Start Date: 5/13/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: APR 22 2016

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI9612	A
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IIN-D412-702-3	A
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100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD412-702-071 CHG003

MLJ 16-04-28 (4)

88016

4

DAS
28
9-89

APR 28 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

4

DAS
6
9-89
DAS
27
9-89

APR 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Work Order ID 144684

April 21, 2016 4:20:40 PM

144684

Page 2

Item ID: D412-702-071

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Comfort Crew Shoulder Harness

Start Date: 5/13/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00				4			
120									
QC	Memo	0.03						DAS 28 9-89	APR 28 2016
Quality Control									
130	Packaging	0.00				4			
130									
Packaging	Memo	0.00						DAS 28 9-89	APR 28 2016
Packaging	Identify and pack for shipping as per PPP D412-702-071 Location: FG029								
	X3 X1 sold								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10				MCS			APR 28 2016
Quality Control									

APR 28 2016

MCS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
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OTHER : ☐									

Picklist Print

April 21, 2016 4:20:39 PM

Page 1

Work Order ID: 144684

144684

Parent Item: D412-702-071

D412-702-071

Parent Item Name: Comfort Crew Shoulder Harness

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.01 new issue DD verf:EC
12.09.05 per DSI9612 DD verf:JFS

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4305-041		Manufactured	No			110	Each	19.0000	1	14		DAS 6 9-89	DAS 27 9-89
D4305-041									**				
Shoulder Harness Assembly													

Location	Loc Qty	Loc Code
QRTN	7	
98837	7	
ST469	12	
105828	12	

AN3-4A

Purchased

No

110

Each

306.0000

4

16

DAS
6
9-89
DAS
27
9-89

AN3-4A

Bolt

**

Location	Loc Qty	Loc Code
over003	300	
m134502	300	
ST350	6	
m133990	6	

AN4-6A

Purchased

No

110

Each

500.0000

2

28

DAS
6
9-89
DAS
27
9-89

AN4-6A

BOLT

**

Location	Loc Qty	Loc Code
over003	200	
M134508	200	
ST345	300	
M130851	39	
M133790	261	

DAS
28
9-89

APR 28 2016

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WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Work Order ID: 144684

144684

Parent Item: D412-702-071

D412-702-071

Parent Item Name: Comfort Crew Shoulder Harness

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No

110 Each 228.0000 2 *28*

AN3-10A

Bolt

*DAS
28
9-89*

Location	Loc Qty	Loc Code
GA	1	
m132763	1	
over003	100	
m134249	100	
ST349	127	
m133992 <i>16</i>	27	
m134573	100	

*DAS
27
9-89*

MS21042L3 Purchased No

110 Each 1,588.000 6 *24*

MS21042L3

Nut

*DAS
28
9-89*

Location	Loc Qty	Loc Code
FP001	100	
m133790	100	
GA	782	
m133790	3	
m134360	779	
ST303	706	
m134039	12	
m134360	694	

*DAS
27
9-89
APR 28 2016*

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Work Order ID: 144684

144684

Parent Item: D412-702-071

D412-702-071

Parent Item Name: Comfort Crew Shoulder Harness

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

2,210.000

2

~~2~~ 8

DAS

6

9-89

DAS

27

9-89

MS21042L4

Locknut

**

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	288	
m133769	288	
OVER007	1500	
m134509	500	8
m134606	1000	
ST303	325	
m134055	1	
m134502	324	
ST305	97	
m130922	97	

NAS1149D0332J

Purchased

No

110

Each

1,480.000

10

~~10~~ 40

NAS1149D0332J

Washer

**

DAS

6

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

CA	6	
m129682	6	
FP001	4	
m133988	4	
GA	88	
m132677	88	
ST260a	1000	
m134502	1000	
ST264	382	
m133988	382	40

DAS
28
9-89

APR 28 2016

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Shop Packet Print

Page 3

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :					

Picklist Print

April 21, 2016 4:20:40 PM

Page 4

Work Order ID: 144684

144684

Parent Item: D412-702-071

D412-702-071

Parent Item Name: Comfort Crew Shoulder Harness

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

110

Each

1,903.000

6

24

NAS1149D0363.J

Washer

**

DAS

27

DAS 9-89

6

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

583

m134055

583

ST263

1320

m134370

320

m134606

1000

NAS1149D0432J

Purchased

No

110

Each

26.0000

4

24

NAS1149D0432.J

WASHER

**

DAS

27

6

9-89

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

26

m131026

26

NAS1149D0463J

Purchased

No

110

Each

3,137.000

4

16

NAS1149D0463.J

WASHER

**

DAS

27

6

9-89

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

383

M129390

41

M132035

21

M134508

321

ST260a

1725

M134508

600

M134573

1125

ST263

41

M134039

41

ST269

988

M132317

100

M132677

888

DAS

27

6

9-89

27

9-89

6

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9-89

APR 28 2016

April 21, 2016 4:20:40 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY					
Environment ☐		No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐		Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐		Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐		Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐		Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐		Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐		Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐		Manufacturing Process ☐	OTHER : _____					
Misidentified ☐		Past Due ☐						

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-702-3 REV. A OR EARLIER

AND ICA-D412-702 REV. 4 OR EARLIER

REF CANADIAN STC: SH04-7

REF FAA STC: SR01997NY

REF EASA STC: EASA.IM.R.S.00710

1.0 PURPOSE

THE PURPOSE OF THIS DSI IS TO CORRECT THE HARDWARE CALLED OUT IN THE D412-702-071 KIT.

2.0 WEIGHT AND BALANCE

NO CHANGE.

3.0 PARTS LIST

IS:

QTY -071	P/N	DESCRIPTION
X	D412-702-071	DART PILOT/CO-PILOT SHOULDER HARNESS KIT
1	D4305-041	SHOULDER HARNESS
4	AN3-4A	BOLT
2	AN4-6A	BOLT
2	AN3-10A	BOLT
6	MS21042L3	NUT
2	MS21042L4	NUT
10	NAS1149D0332J	WASHER
6	NAS1149D0363J	WASHER
4	NAS1149D0432J	WASHER
4	NAS1149D0463J	WASHER

WAS:

QTY -071	P/N	DESCRIPTION
X	D412-702-071	DART PILOT/CO-PILOT SHOULDER HARNESS KIT
1	D4305-041	SHOULDER HARNESS
4	AN3-4A	BOLT
2	AN3-6A	BOLT
2	AN3-7A	BOLT
14	NAS1149D0332J	WASHER
8	NAS1149D0363J	WASHER
8	MS21042L3	NUT

REF COPY
9/1/2010
ENGINEERING
CONTROLLED COPY
NOT TO AMENDMENT
OF THIS NOTICE
WORK ORDER
144685MCS
1604-22

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

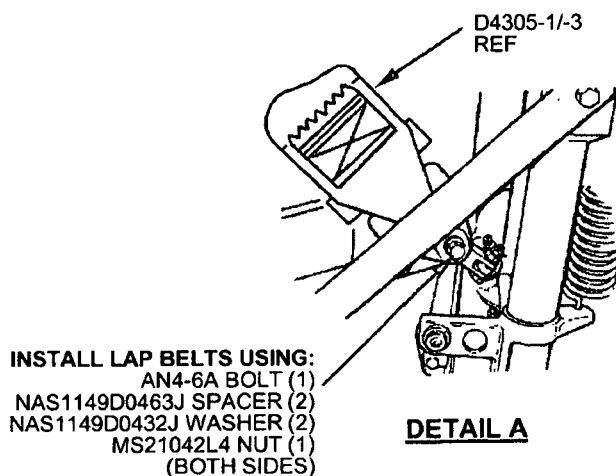
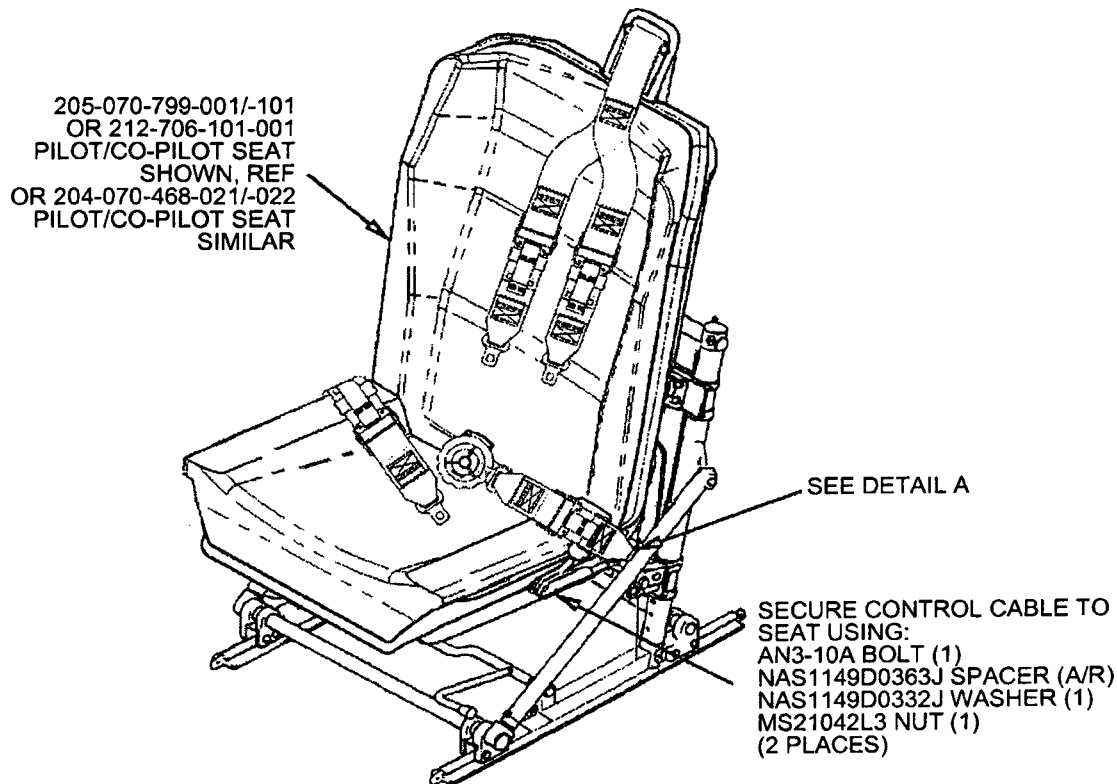
BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 12.05.01
CERT. NO.: SH04-7
ISSUE NO.: 3

A	NEW ISSUE	RP	12.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>AL</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9612	SHEET 1 OF 2
APPROVED	<u>[Signature]</u>	TITLE	PILOT/CO-PILOT HARNESS SCALE
DE APPR.	<u>[Signature]</u>	UPDATES	NTS
DATE	12.05.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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4.0 CHANGES

FIGURE 2. - DART D412-702-071 LAP BELT INSTALLATION (REF: IIN-D412-702)
FIGURE 25.18 DART D412-702-071 PILOT/CO-PILOT SHOULDER HARNESS KIT (REF: ICA D412-702)



INSTALL LAP BELTS USING:
AN4-6A BOLT (1)
NAS1149D0463J SPACER (2)
NAS1149D0432J WASHER (2)
MS21042L4 NUT (1)
(BOTH SIDES)

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	<i>AL</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9612	SHEET 2 OF 2
APPROVED	<i>RP</i>	TITLE	PILOT/CO-PILOT HARNESS SCALE
DE APPR.	<i>TH</i>	UPDATES	NTS
DATE	12.05.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-702-3 REV. A OR EARLIER
AND ICA-D412-702 REV. 4 OR EARLIER
REF CANADIAN STC: SH04-7
REF FAA STC: SR01997NY
REF EASA STC: EASA.IM.R.S.00710

CONFIDENTIAL ONLY

DAS
28
9-89

1.0 PURPOSE

THE PURPOSE OF THIS DSI IS TO CORRECT THE HARDWARE CALLED OUT IN THE D412-702-071 KIT.

2.0 WEIGHT AND BALANCE

NO CHANGE.

3.0 PARTS LIST

IS:

QTY -071	P/N	DESCRIPTION
X	D412-702-071	DART PILOT/CO-PILOT SHOULDER HARNESS KIT
1	D4305-041	SHOULDER HARNESS
4	AN3-4A	BOLT
2	AN4-6A	BOLT
2	AN3-10A	BOLT
6	MS21042L3	NUT
2	MS21042L4	NUT
10	NAS1149D0332J	WASHER
6	NAS1149D0363J	WASHER
4	NAS1149D0432J	WASHER
4	NAS1149D0463J	WASHER

WAS:

QTY -071	P/N	DESCRIPTION
X	D412-702-071	DART PILOT/CO-PILOT SHOULDER HARNESS KIT
1	D4305-041	SHOULDER HARNESS
4	AN3-4A	BOLT
2	AN3-6A	BOLT
2	AN3-7A	BOLT
14	NAS1149D0332J	WASHER
8	NAS1149D0363J	WASHER
8	MS21042L3	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 12.05.01
CERT. NO.: SH04-7
ISSUE NO.: 3

A	NEW ISSUE	RP	12.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	al	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9612	SHEET 1 OF 2
APPROVED	MP	TITLE	PILOT/CO-PILOT HARNESS SCALE
DE APPR.	MP	UPDATES	NTS
DATE	12.05.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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